

Work Order ID 51389

August 20, 2009 3:36:30 PM



Page 1

Item ID: D3508-7 **GY** Accept

Revision ID: C

Item Name: Wearplate

Start Date: 08/24/2009 Start Qty: 12.00

Required Date: 08/28/2009 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: MF Date: 09-08-20 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3508	Rev C

100 0.00



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3508 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 12-
Deburr if necessary

B 9-9-16

110 0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

B 9-9-16

120 0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

2) 8/28/09/14

(x12) /

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

August 20, 2009 3:36:30 PM

Page 1

Work Order ID: 51389



Parent Item: D3508-7RevC



Parent Item Name: Wearplate

Start Date: 08/24/2009

Required Date: 08/28/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	63.3940	3.9360			



304/316 .040 Sheet

B 9-9-15

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

63.39404737

110076

31.73

111571

31.6640474

112567

112567

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DART AEROSPACE LTD		Work Order: 51389
Description: Wearplate		Part Number: D3508-7
Inspection Dwg: D3508	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.063	+/-0.010	2.066	✓			
2.813	+/-0.010	2.808	✓			
Ø0.188	+0.005/-0.001	.181	✗			
0.375	+/-0.010	.375	✓			
6.875	+/-0.010	6.873	✗			
13.750	+/-0.010	13.750	✓			
16.10	+/-0.030	16.10	✗			
0.300	+/-0.010	.304	✗			
0.300	+/-0.010	.302	✗			
0.040	+/-0.010	.035	✗			

Measured by: HR	Audited by: J	Prototype Approval: N/A
Date: 9-9-16	Date: 09/09/16	Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.05.07	New Issue	KJ/EC	

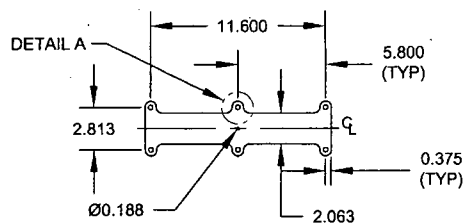
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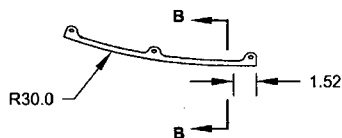
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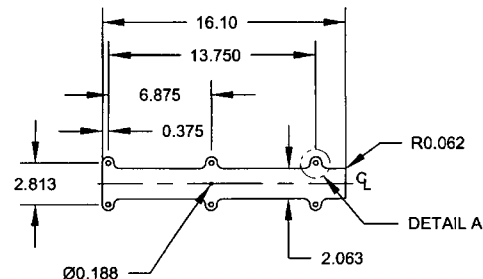
NOTE: Date & initial all entries



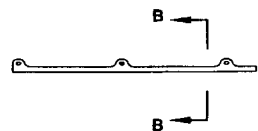
D3508-1 FLAT PATTERN



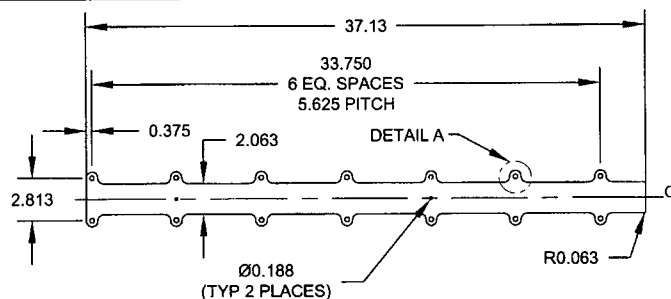
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



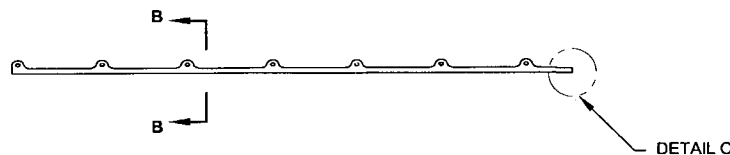
D3508-7F FLAT PATTERN



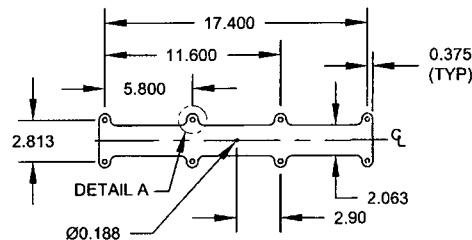
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(MAKE FROM D3508-7F)



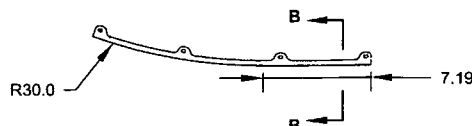
D3508-3 FLAT PATTERN



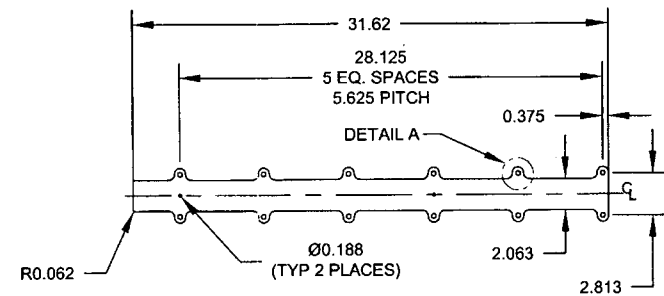
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



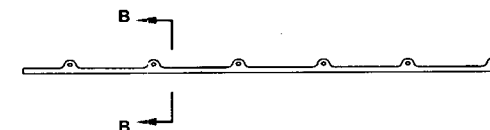
D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)



D3508-5 FLAT PATTERN



D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

RELEASED
07-11-16

C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE

DESIGN	<i>244</i>	DART AEROSPACE USA, INC PORT HADLOCK, WA
DRAWN	<i>244</i>	
CHECKED	<i>140</i>	DRAWING NO. REV. C
MFG. APPR.	<i>140</i>	D3508 SHEET 1 OF 2
APPROVED	<i>140</i>	TITLE SCALE
DE APPR.	<i>140</i>	WEARPLATE 1:
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

51389

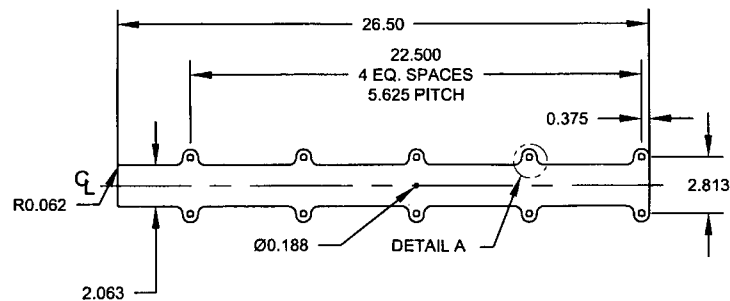
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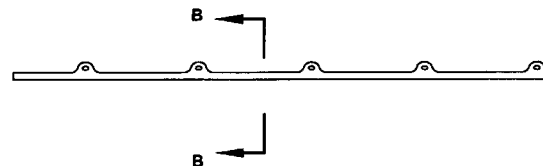
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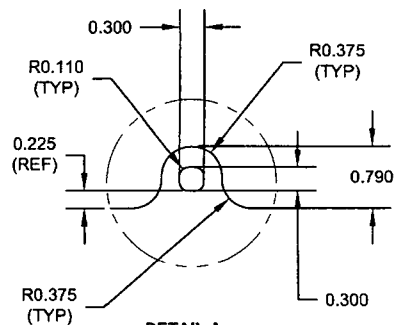
NOTE: Date & initial all entries



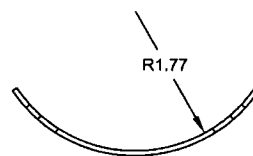
D3508-11F FLAT PATTERN



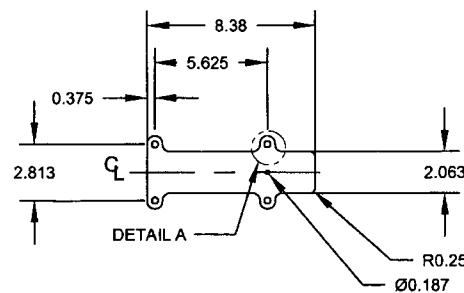
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



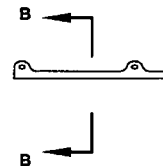
DETAIL A
(SCALE 2:3)



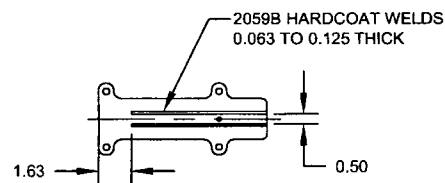
SECTION B-B
(SCALE 2:3)



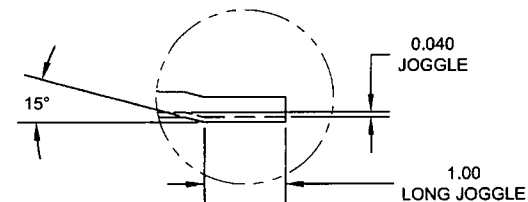
D3508-13F FLAT PATTERN



D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



D3508-13 WELDING DETAIL



DETAIL C
(SCALE 1:2)

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3508	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE	1:6
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#51389
MF
09-08-20

51389

RELEASED
07-11-16

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